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D5331-041
Job Sheet 185734



Part No: D5331-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27
add D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	1 pcs	11/16/18	11/16/18	0.00	15.77	Large Fab 1		
110	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC9		
120	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC5		
125	HandFinish	1 pcs	11/16/18	11/16/18	0.00	2.34	HandFinish2		
130	Powdercoat	1 pcs	11/16/18	11/16/18	0.00	0.53	Powdercoat2		
140	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC3		
170	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs and weld as per dwg D5331 using DT10197 ***inspect before welding mesh*** (54.63

Descriptions: CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3- Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate hinge and bracket*** ***On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg (CRITICAL)

130 - 1- Plug holes and mask only interior of hinge (6) prior to powder coat 1ST COAT: START TIME: 10:50
OVEN TEMPERATURE: 375° FINISH TIME: 11:05 *****2nd coat if necessary***** 2ND
COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	S 108 601
D3913-15 ✓	Wide Handle Plate	1 Ea (1 ea) ✓	90-Start up Operation	S 108 592
D3916-5 ✓	Light Rib	2 Ea (2 ea) ✓	90-Start up Operation	S 117 380
D4016-1 ✓	Hinge Half, Base	6 Ea (6 ea) ✓	90-Start up Operation	S 112 356
D4016-7 ✓	Stop	1 Ea (1 ea) ✓	90-Start up Operation	S 097 165
D4021-1 ✓	Handle Plate	1 Ea (1 ea) ✓	90-Start up Operation	S 108 590
D5325-041 ✓	Rib Assembly	1 Ea (1 ea) ✓	90-Start up Operation	S 101 588
D5325-3 ✓	Light Rib	1 Ea (1 ea) ✓	90-Start up Operation	S 127 163
D5325-5 ✓	Foot	4 Ea (4 ea) ✓	90-Start up Operation	S 100 095 9/01519
D5326-041 ✓	Rib Assembly	1 Ea (1 ea) ✓	90-Start up Operation	S 127 320
D5326-043 ✓	Rib Assembly	1 Ea (1 ea) ✓	90-Start up Operation	S 109 804
D5327-1 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	S 158 897
D5327-11 ✓	Rib	4 Ea (4 ea) ✓	90-Start up Operation	S 127 039

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification ☐
		QC / QA Coordinator Approval ☐

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐			

D5327-13 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation
D5327-15 ✓	Cap	1 Ea (1 ea) ✓	90-Start up Operation
D5327-3 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation
D5327-5 ✓	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-7 ✓	Rib	1 Ea (1 ea)	90-Start up Operation
D5327-9 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation
D5328-3	Mesh Base, Aft	1 Ea (1 ea)	90-Start up Operation
D5328-5	Mesh Base, Fwd	1 Ea (1 ea)	90-Start up Operation
D5329-1 ✓	Gusset	2 Ea (2 ea) ✓	90-Start up Operation
D5330-1 ✓	Handle Plate	2 Ea (2 ea) ✓	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

5067675
 5108289
 5127015
 5127616
 5127694
 5127080
 5094851
 504849
 5089969
 5054668
 5093684

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	42	0
	D3913-15	1	16	0
	D3916-5	2	11	0
	D4016-1	6	214	0
	D4016-7	1	9	0
	D4021-1	1	25	0
	D5325-041	1	1	0
	D5325-3	1	0	0
	D5325-5	4	4	0
	D5326-041	1	0	0
	D5326-043	1	3	0
	D5327-1	1	1	0
	D5327-11	4	2	0
	D5327-13	1	7	0
	D5327-15	1	16	0
	D5327-3	1	0	0
	D5327-5	1	0	0
	D5327-7	1	0	0
	D5327-9	2	0	0
	D5328-3	1	1	0
	D5328-5	1	5	0
	D5329-1	2	6	0
	D5330-1	2	4	0
	M304EX0.75-16F	32	1,189	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	
			Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

FAULT CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence

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In
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Container No: S128812



Part: D5331-041

Job No: 185734

Serial No/Batch: S128812

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/18/18